

5/4/4

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|-------------------------------|--------------|----------------------------------|
| DART AEROSPACE LTD | Work Order: | 24267 |
| Description: Bracket Assembly | Part Number: | D3121-144 |
| Dwg: D3121 Rev. C | Qty: | 3 KIT(S) 1/2 04.02.27 |

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| Step | Location | Procedure | By | Date | Qty |
|------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|----------|----------|
| 1 | DC | Issue Traveler Dwg not required | AB | 05.09.14 | 3 |
| 2 | MV | Cut blank: (1.000" x 2.000") 4.425" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-114 | | | |
| 3 | MV | Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114 | AB | 05/09/14 | 3 |
| 4 | QC2 | Inspect parts as they come off the CNC machine | AB | 05.10.08 | 3 |
| 5 | MV | Deburr | AB | 05.10.08 | 3 |
| 6 | MV | Scribe batch number | AB | 05.10.08 | 3 |
| 7 | QC8 | Second check | SD | 05.10.09 | 3 |
| 8 | GA | Assemble D3121-144 as per Dwg D3121. Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> 2 D3121-21 Bolt 2 D3121-241 Bearing Assembly Identify as D3121-144 | B244953 Batch 1523914 1524282 | CD | 05/10/17 |
| 9 | QC5 | Inspect work to Step 8 | AB | 05.10.17 | 3 |
| 10 | ST | Identify and Stock | CD | 05/10/19 | 3 |
| 11 | AC | Cost / part | JWZ | 05-12-02 | J |
| 12 | DC | Close W/O Inspect Level 21 | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| AB | 04.02.18 | New issue | KJ/DS | AB |

RF 04.02.19

RELEASED
04.02.19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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| DART AEROSPACE LTD | Work Order: | 24267 |
| Description: Bracket | Part Number: | D3121-114 |
| Inspection Dwg: D3121 | Rev: C2 | Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------------|
| 0.080 | +/-0.010 | .080 | ✓ | | | |
| 0.300 | +/-0.010 | .298 | ✓ | | | |
| R0.375 | +/-0.010 | .375 | ✓ | | | |
| 1.54 | +/-0.030 | 1.541 | ✓ | | | |
| 0.350 | +/-0.010 | .352 | ✓ | | | |
| R0.250 | +/-0.010 | .250 | ✓ | | | |
| 1.800 | +/-0.030 | 1.805 | ✓ | | | |
| Ø0.392 | +0.002/-0.000 | .392 | ✓ | | | To fit bearing |
| Ø0.201 | +0.005/-0.000 | .201 | ✓ | | | |
| 0.100 | +/-0.010 | .100 | ✓ | | | |
| | | | | | | |
| 2.540 | +/-0.010 | 2.540 | ✓ | | | |
| 1.590 | +/-0.010 | 1.590 | ✓ | | | |
| 0.160 | +/-0.010 | .160 | ✓ | | | |
| 0.400 | +/-0.010 | .399 | ✓ | | | |
| 1.220 | +/-0.010 | 1.220 | ✓ | | | |
| 1.600 | +/-0.010 | 1.606 | ✓ | | | |
| 3.80 | +/-0.030 | 3.800 | ✓ | | | |
| 1.800 | +/-0.010 | 1.805 | ✓ | | | |
| R0.500 | +/-0.010 | .500 | ✓ | | | |
| 0.130 | +/-0.010 | .132 | ✓ | | | |
| 3.41 | +/-0.030 | 3.40 | ✓ | | | |
| 3.65 | +/-0.030 | 3.630 | ✓ | | | |
| 2.24 | +/-0.030 | 2.210 | ✓ | | | |
| 45° | +/-0.1° | 45° | ✓ | | | |
| R0.250 | +/-0.010 | .250 | ✓ | | | |
| 3.97 | +/-0.030 | 3.970 | ✓ | | | |
| | | | | | | |
| R0.38 | +/-0.030 | .375 | ✓ | | | |
| Ø0.392 | +0.002/-0.000 | .392 | ✓ | | | To fit bearing |
| Ø0.201 | +0.005/-0.000 | .201 | ✓ | | | |
| 0.100 | +/-0.010 | .100 | ✓ | | | |
| 0.268 | +/-0.010 | .268 | ✓ | | | |
| R0.260 | +/-0.010 | .260 | ✓ | | | |
| 0.080 | +/-0.010 | .080 | ✓ | | | |
| 0.300 | +/-0.010 | .300 | ✓ | | | |
| | | | | | | |

RELEASED

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|-------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 24267 |
| Description: Bracket | Part Number: | D3121-114 |
| Inspection Dwg: D3121 Rev: C2 | | Page 2 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | BG | Audited by: | SD | Prototype Approval: | N/A |
| Date: | 05.10.08 | Date: | 05.10.08 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------------------------------|------------|----------|
| A | 03.12.08 | New Issue P/O D3121-144 | KJ/RF | |
| B | 04.05.05 | Dimensions changed/re-arranged per Dwg revision | KJ/JLM | |

RELEASED

~~✓ 11/05/05~~